

# Work Order ID 53691

November 12, 2009 3:57:50 PM



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Item ID: D212-664-201

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Aft

Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109111

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date: 05-11-12

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-664-241

Rev C

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Original B47382 (and even more original is B44192: the order it was made on) at CHG003.  
Kit complete & good condition.

1 05-11-12

110

Identify as per dwg & Stock Location: 0.00



Packaging

Memo

0.00

Packaging

New labels with the new batch # required @ CHG003.  
Clean; repackage & return to stock.

RL 09-11-13  
1-9/11/16 @

120

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/11/17

MR 09-11-16

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D212-664-201	CHG	CHG003		
DESC	Crosstube Aft High	STC	SH01-9		
LOT	B47382	STC	SR01298NY		
MODEL	Bell 204/205/210/212/UH-1	STC			
MADE IN CANADA					
D2729-1					

Date: Wednesday, 22/04/2009 2:48:19 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D212-664-201
Job Number	: 47382		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D212664201
This Issue	: 22/04/2009 S.O. No. :	Drawing Number	: R09-042
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 29/04/2009 Qty: 1 Ums: Each
Checked & Approved By	: <u>JW 09.04.22</u>		
Comment	:		

REFERENCE ONLY

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D212664201	Crosstube Aft High, 204/205/212
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Crosstube Aft High, 204/205/212 Original B44192 @ CHG003 ✓		
2.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>29/04/22</u> (1)		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 -New paperwork, decal and label required with the new batch # @ CHG003 -Clean the tube and re-package with the original kit. -Return to stock: -Location: <u>PU 8/4/23</u> (1)		
4.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <u>09/05/15</u> (1)		

Job Completion



<b>DART</b> Dart Aerospace Ltd. 127 ASHDEEN ST HAMPSHIRE ON CANADA		TC APPROVAL # 09-89 TEL 1-613-632-5200	
D212-664-201		CHG003	
Crosstube Aft High		SH01-9	
B44192		SR01298NY	
Bell 204/205/210/212/214			
MADE IN CANADA		D2729-1	

mf  
09-05-  
14

Date: Thursday, 11/12/09 9:56:39 AM

User: Jason Murdoch

**JOB HISTORY : DETAIL**

<b>Job Number</b>	44192		<b>Customer</b>	Dart Helicopters Services LLC.		
<b>Estimate Number</b>	10257		<b>DWG Name</b>	212/205 HIGH AFT X-TUBE ASSEMBLY		
<b>Purchase Order #</b>			<b>Part Number</b>	D212664201		
<b>Complete Date</b>	01/22/09 11:36:01 AM		<b>DWG Number</b>	D212-664-241 REV C		<b>Rev.</b> : C

  

DUE DATE	ORDERED	DELIVERED
01/09/09	1	1

  

<b>3.0 D212664201TRN-Crosstube Turning Detail</b>							<b>INVENTORY IT</b>
DATE	EMPLOYEE	TYPE	Qty		COST		
01/14/09	BRUN01: Brunet, Marc	D212664201TRN	1.000		\$1077.90	Lot # 44155 Qty. 1	
<b>Subtotal:</b>			QTD:	0	CTD:	1 \$1077.90	

  

<b>4.0 BENDING</b>							<b>Internal Operation</b>
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/14/09	PAQU03: Paquette, Dan	Setup	0.000	0.20	\$3.80	0.40	17.02
01/14/09	BRUN01: Brunet, Marc	Setup	0.000	0.24	\$4.56	0.49	20.85
01/14/09	BRUN01: Brunet, Marc	Run	1.000	1.55	\$29.43	1.55	65.92
01/14/09	PAQU03: Paquette, Dan	Run	1.000	1.57	\$29.81	1.57	66.77
<b>Subtotal:</b>			QTD:	2	CTD:	0 3.56 \$238.16	

  

<b>6.0 CROSSTUBES</b>							<b>Internal Operation</b>
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/15/09	BRUN01: Brunet, Marc	Run	1.000	1.91	\$36.27	1.91	89.59
<b>Subtotal:</b>			QTD:	1	CTD:	0 1.91 \$125.86	

  

<b>7.0 HAND FINISHING1</b>							<b>Internal Operation</b>
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/15/09	BRUN01: Brunet, Marc	Run	1.000	0.86	\$16.33	0.86	39.68
<b>Subtotal:</b>			QTD:	1	CTD:	0 0.86 \$56.01	

  

<b>10.0 OUTSIDE SERV.11</b>							<b>Sub-contr./External OP.</b>
DATE	EMPLOYEE	TYPE	Qty		COST		
01/20/09	LAVO01: Lavoie, Chantal	IN	1.000		\$82.85		
<b>Subtotal:</b>			QTD:	0	CTD:	1 \$82.85	

  

<b>13.0 SPRAY PAINTING</b>							<b>Internal Operation</b>
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/19/09	MURD02: Murdoch, Matthew	Run	0.000	0.63	\$10.18	0.63	24.74
01/19/09	MURD02: Murdoch, Matthew	Run	0.000	0.50	\$8.08	0.50	19.63
<b>Subtotal:</b>			QTD:	0	CTD:	0 1.13 \$62.63	

  

<b>15.0 D29401-Support</b>							<b>INVENTORY ITEM</b>
DATE	EMPLOYEE	TYPE	Qty		COST		
01/22/09	FAUT01: Fauteux, Melanie	D29401	2.000		\$536.72	Lot # 40753 Qty. 2	
<b>Subtotal:</b>			QTD:	0	CTD:	2 \$536.72	

  

<b>16.0 D3595063530-RUBBER CUSHION</b>							<b>INVENTORY ITEM</b>
DATE	EMPLOYEE	TYPE	Qty		COST		
01/22/09	FAUT01: Fauteux, Melanie	D3595063530	4.000		\$2.10	Lot # 39255 Qty. 4	
<b>Subtotal:</b>			QTD:	0	CTD:	4 \$2.10	

Date: Thursday, 11/12/09 9:56:39 AM

User: Jason Murdoch

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 44192	<b>Customer</b>	: Dart Helicopters Services LLC.
<b>Estimate Number</b>	: 10257	<b>DWG Name</b>	: 212/205 HIGH AFT X-TUBE ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D212664201
<b>Complete Date</b>	: 01/22/09 11:36:01 AM	<b>DWG Number</b>	: D212-664-241 REV C
		<b>Rev.</b>	: C

**17.0 MS2192028-Clamp(per MIL-DTL-8783C) INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/22/09	FAUT01: Fauteux, Melanie	MS2192028	4.000		\$61.00	Lot # 109181 Qty. 4
<b>Subtotal:</b>			QTD: 0 CTD: 4		\$61.00	

**18.0 CROSSTUBES Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost	
01/20/09	TITL01: Titley, Ian	Run	1.000	1.16	\$18.75	2.32	92.60	
01/21/09	MURD02: Murdoch, Matthew	Run	0.000	0.41	\$6.63	0.41	16.38	
<b>Subtotal:</b>			QTD: 1 CTD: 0	1.57	\$134.36			

**21.0 D34281-Placard INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/21/09	DESJ02: Desjardins, Line	D34281	1.000		\$5.24	Lot # 42448 Qty. 1
<b>Subtotal:</b>			QTD: 0 CTD: 1		\$5.24	

**22.0 AN640A-Bolt INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/21/09	DESJ02: Desjardins, Line	AN640A	4.000		\$15.60	Lot # 108940 Qty. 4
<b>Subtotal:</b>			QTD: 0 CTD: 4		\$15.60	

**23.0 AN641A-Bolt INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/21/09	DESJ02: Desjardins, Line	AN641A	2.000		\$4.86	Lot # 107013 Qty. 2
<b>Subtotal:</b>			QTD: 0 CTD: 2		\$4.86	

**24.0 AN960JD616-Washer INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/21/09	DESJ02: Desjardins, Line	AN960JD616	18.000		\$1.44	Lot # 110002 Qty. 18
<b>Subtotal:</b>			QTD: 0 CTD: 18		\$1.44	

**25.0 MS21042L6-Nut INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty		COST	
01/21/09	DESJ02: Desjardins, Line	MS21042L6	6.000		\$4.71	Lot # 19099 Qty. 6
<b>Subtotal:</b>			QTD: 0 CTD: 6		\$4.71	

		TIME	COST
Machine Time:		10.64	\$453.18
Labor:		9.03	\$163.84
Sub-contract (external Op.):			\$82.85
INVENTORY ITEM:			\$1709.57
SUB-COMPONENT (SUB-JOB):			\$0.00
<b>Total:</b>			\$2409.44
COST PER UNIT:			\$2409.44